

Green

Date: Thursday, 22/01/2009 7:57:46 AM
User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLADE POSITIONER WELDMENT	
Job Number :	45032			
Estimate Number :	13443			
P.O. Number :		Part Number :	PB674300129	
This Issue :	22/01/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	B6743001 P.40	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	43056	Drawing Revision :	B1	
	Type :	Material :		
	LARGE FAB ASSY	Due Date :	28/01/2009	Qty: 8 Um: Each
Written By :				
Checked & Approved By :	<i>MF 09-01-22</i>			
Comment :	Est Rev:A 08-06-27 new issue DD verified by:ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001313	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Plate
batch: *B 44968*

MF 09-02-13

2.0	PB6743001319	Gusset
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Gusset
batch: *B 40067 x 1, 12 x 41504, B 44967 x 3*

09-02-13

3.0	PB6743001337	Upper Pad Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Upper Pad Assembly
batch: *B 41506 x 12 mx, B 44966 x 4 mx*

MF 09-02-13

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO WELDING****

1- ASSEMBLE AND WELD AS PER DWG

SP 09.02.19

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

BE 09/02/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER WELDMENT

Job Number: 45032

Part Number: PB674300129

Job Number:



Seq. #:

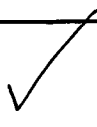
Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



09-02-198



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

JS

09-02-23

(X8)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 8:30 AM

OVEN TEMPERATURE: 320°C

FINISH TIME: 9:00 AM

JS

09-02-23

(X8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

09-02-23

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST447



JS

09/02/23 (X8)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



09/02/24 JS

Job Completion



MF 09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

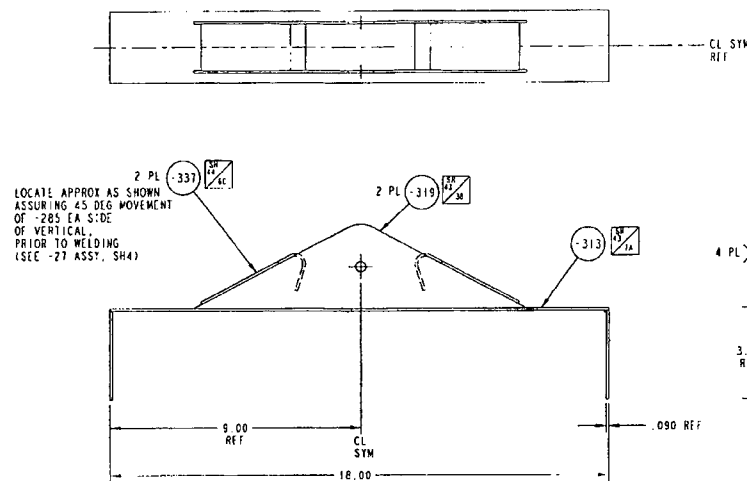
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

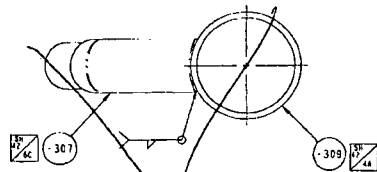
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
06 01 20

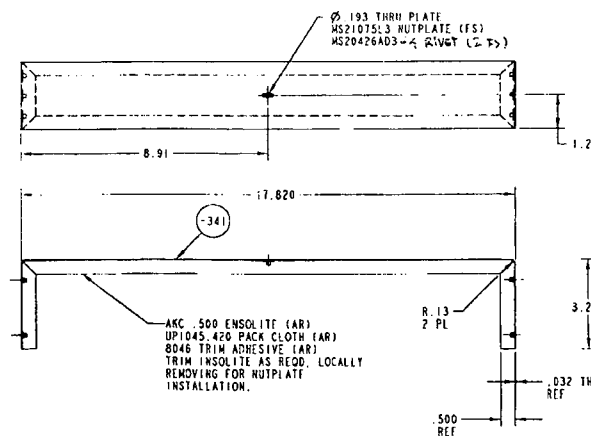


① -29 BLADE POSITIONER WELDMENT
SCALE 0.500



-25 TUBE GUIDE WELDMENT
SCALE 1.000

SUPERCEDED BY
D3440-1 & D3440-3



① -35 LOWER PAD ASSY
SCALE 0.500
MATERIAL FOR -34: .032 THK 2024-T3, 00-A-250/4

PREMIER AVIATION, INC.
2001 Aviation Parkway, Grand Prairie, Texas 75052
D3440-1 B67-43001 B1
SCALE: 1:1 SHEET 40 OF 45

ORIGINAL